

SHIP FRIDAY

Work Order ID 58313



Page 1

May 3, 2010 11:42:06 AM

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 03/05/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MPDate: 10-5-3

Tooling:

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4030

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

120

QC5- Inspect part completeness to step on W/O

0.00

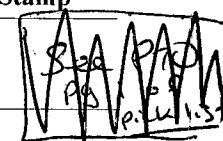


QC

Memo

0.00

Quality Control



EB 10/05/13 ①

EB 10/05/13 ②

S 10/05/14

④

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Accept

Revision ID:

Item Name: Long Basket Assembly (350)

Start Date: 03/05/2010 **Start Qty:** 1.00

Required Date: 13/05/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

**Insp.
Stamp**

130

Identify as per dwg & Stock Location:

0.00

[illegible]

Packaging

Packaging

W/O 58319
Memo

0.00

D 380-607-441

140

QC21- Final Inspection - Work Order Release

0.00

[illegible]

QC

Quality Control

Memo

0.00

mf
10-5-14

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 58313

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC






IPP Rev:B as

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	3.0000	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST506		3						
					57736	3						
D2535  Spring		Manufactured	No			100	Each	11.0000	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		11						
					56355	11						
D2537  Bushing		Manufactured	No			100	Each	23.0000	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		23						
					53181	3						
					57722	20						
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1			
D3914-041  Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1			

B58238 @

B58257 @



EP 10/05/13

EP 10/05/13

EP 10/05/13

EP 10/05/13

EP 10/05/13

(P10)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 4030-041 PAR #: 10-034 Fault Category: Eng-drawing NCR: Yes ☒ No ☐ DQA: 1 Date: 10.05.14
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.05.14	100							

NOTE: Date & initial all entries

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Parent Item Name: Long Basket Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
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IPP Rev:B as





Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3917-3  Washer		Manufactured	No			100	Each	1.0000	6			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				ST096				1				
					57144			1				
D3953-3  Gas Spring Stud, Lid		Manufactured	No			100	Each	7.0000	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				ST101				7				
					53757			1				
					57978			6				
D3953-7  Spring Spacer		Manufactured	No			100	Each	15.0000	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				ST101				15				
					53970			15				
D3953-9  Gas Spring Washer		Manufactured	No			100	Each	30.0000	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				ST101				30				
					53642			30				

 *EP 10/05/13*
B58186 (2)
 *EP 10/05/13*
 *EP 10/05/13*
 *EP 10/05/13*

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3953-17  Gas Spring Spacer		Manufactured	No			100	Each	8.0000	2		EP 10/05/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				8				
					57143			8		2		
D3953-19  Gas Spring Bracket		Manufactured	No			100	Each	14.0000	1		EP 10/05/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				14				
					57607			14		1		
D3953-21  Gas Spring Bracket		Manufactured	No			100	Each	22.0000	1		EP 10/05/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ENG				6				
					56407			6				
				ST102				16				
					57145			16		1		
D3969-3  Spring (Basket Lid)		Manufactured	No			100	Each	3.0000	1		EP 10/05/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ENG				3				
					55716			3				
												

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D4030-041



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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-14A Bolt		Purchased	No			100	Each	98.0000	4		EP 10/05/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST351		98						
					114330	98						
AN3-16A Bolt		Purchased	No			100	Each	73.0000	2		EP 10/05/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST352		73						
					111965	3						
					113845	50						
					114523	20						
AN5-17A Bolt		Purchased	No			100	Each	169.0000	4		EP 10/05/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST323		64						
					114324	64						
				ST339		105						
					113538	5						
					114330	100						

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 58313



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 03/05/2010

Required Date: 13/05/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN4-12 Bolt		Purchased	No			100	Each	53.0000	3	 E 510/05/13		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST357				53				
					104016			3				
					114292			50				
AN310-4 NUT		Purchased	No			100	Each	64.0000	3	 E 510/05/13		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST139				30				
					114341			30				
				ST314				14				
					113845			14				
				ST349				20				
					114341			20				
AN310C4 Nut		Purchased	No			100	Each	82.0000	2	 E 510/05/13		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST349				82				
					114306			82				

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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 58313

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC







IPP Rev:B as

Start Date: 03/05/2010

Required Date: 13/05/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L3  Nut		Purchased	No			100	Each	1,762.000	6	 EPB10/05/13		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST300		1762						
				113537		20						
				113644		742						
				114523		1000						
MS21042L5  Nut		Purchased	No			100	Each	697.0000	4	 EPB10/05/13		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST300		697						
				113523		26						
				113537		3						
				114108		168						
				114437		100						
				114449		400						
MS24665-151  Cotter Pin		Purchased	No			100	Each	701.0000	3	 EPB10/05/13		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST309		701						
				17566		701						

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 58313

Parent Item: D4030-041

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Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
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Start Date: 03/05/2010

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS24665-300  Cotter Pin		Purchased	No			100	Each	92.0000	2		EP 10/05/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST309				92				
					105279			2				
					110123			90				
NAS1149F0432P  Washer		Purchased	No			100	Each	93.0000	6		2 EP 10/05/13 M114576 (62)	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST275				93				
					112940			92				
					114405			1				
NAS1149F0563P  Washer		Purchased	No			100	Each	72.0000	4		EP 10/05/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST275				72				
					108471			72				
NAS1149F0332P  WASHER		Purchased	No			100	Each	951.0000	8		EP 10/05/13	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST275				951				
					18057			951				

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W/O:			WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
NAS1149C0432R		Purchased	No			100	Each	186.0000	2			



Washer



Handwritten signature
13/05/13

2

Location

ST297

114292

Loc Qty

186

186

Loc Code

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

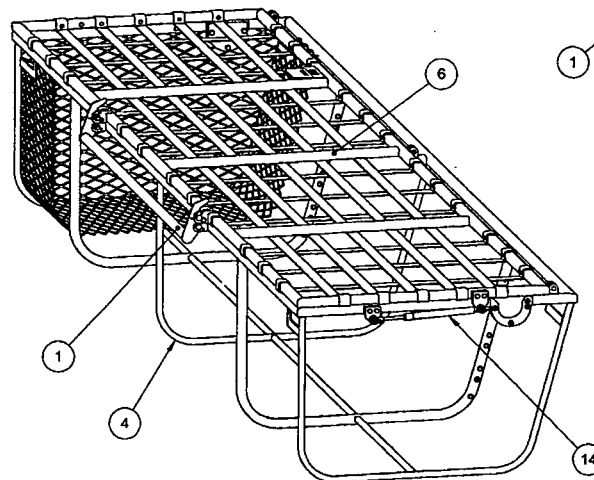
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

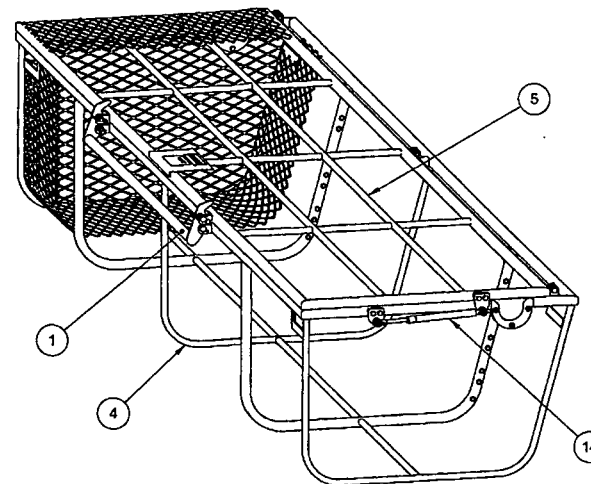
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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8		NAS1149F0332P	WASHER
31	2		NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

5-8313

RELEASED
2010-04-14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. B
CHECKED	JP	D4030	SHEET 1 OF 3
MFG. APPR.	JP	TITLE	SCALE
APPROVED	AM	LONG BASKET ASSY (350)	NTS
DE APPR.	JP	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.04.06		

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

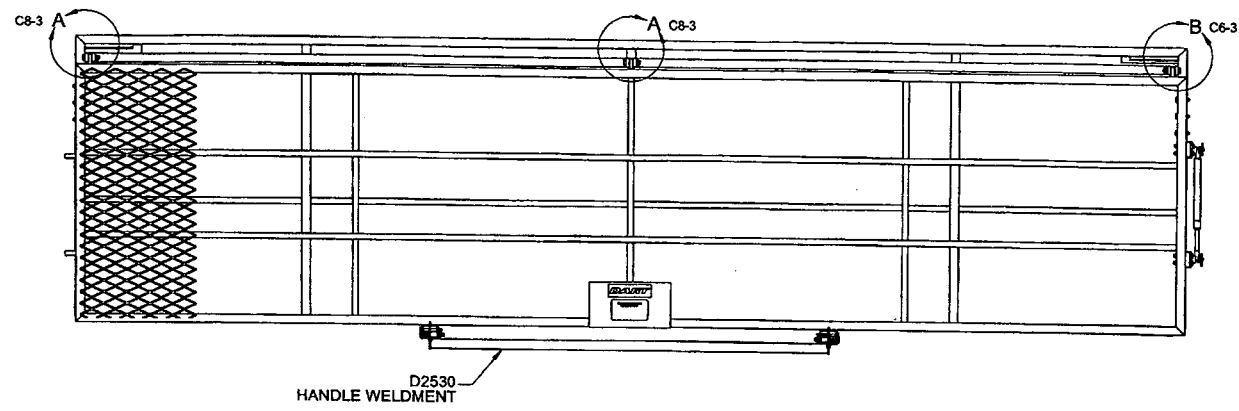
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

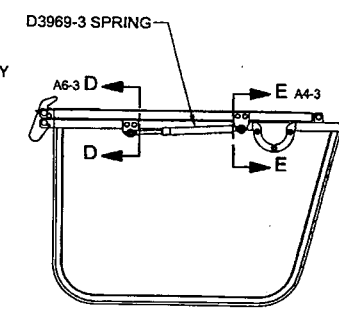
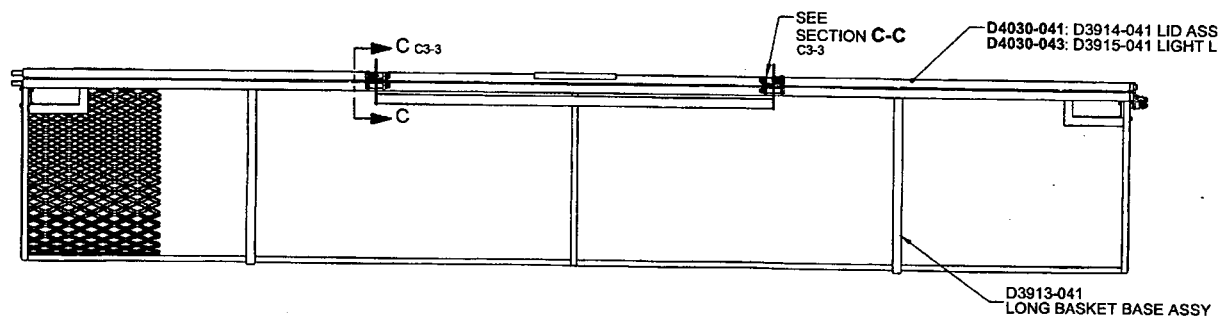
NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



58313



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2010-04-16

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4030	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET ASSY (350)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

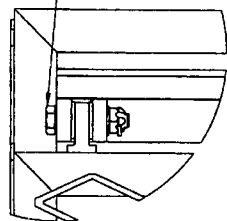
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

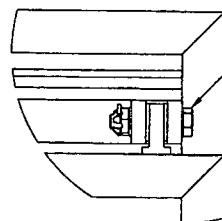
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

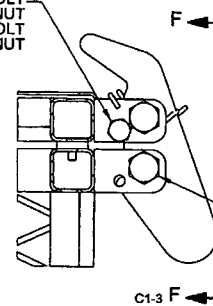


DETAIL A D8-2
D5-2



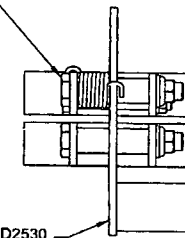
DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

58313

RELEASED
2010-04-14
JMP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. B
MFG. APPR.	GP	D4030	SHEET 3 OF 3
APPROVED	JMP	TITLE	SCALE
DE APPR.	JMP	LONG BASKET ASSY (350)	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries